

Aero Design Ltd.**Work Order Control Sheet**Work Order#: **2017-123** Date Opened: **24 July 2017** Title: **Fabrication**Aircraft OEM: **Multiple** Aircraft Model: **Multiple** Product Type: **Cargo Basket** Product Model: **Handle Bushing** Quantity: **300****Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
 Additional Work Sheets (Standard Practice)
 Drawings (See List Below)
 Parts Distribution Sheet
 Sub Component Tags
 Completed Certification
 Time Sheet (R&D)
 Notes

Initial or N/A

JC
N/A
JC
N/A
N/A
JC
N/A
N/A

Build Sheet Contents

Tasks Initialled
 Dual Inspections Initialled

Initial or N/A

JC
N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
100224	0	Bushing	JC

Traveller

Initial or N/A

Component Completion

Quantity Complete on This Work Order
 Quantity Incomplete on This Work Order
 Further Processing Required Before Release
 Release to Stock as Components

As Instructed

349
N/A
N/A
N/A

Certification

Form One Completed
 Serviceable (Green) Tag Completed
 In Process (Yellow) Tag Completed
 Unserviceable (Red) Tag Completed
 Parts Placed in Stores for Distribution

Initial or N/A

JC
JC
KB
N/A
JC

Additional Documentation

Documentation of a minor change
 Non-Conformance Report Required
 Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
 Research and Development
 Third Party

Initial or N/A

JC
N/A
N/A

Notes:

Work performed by:

Print: K. Bevans

Sign: *Kedy Beron*

SCA: AD10

Date: 18-Aug-17

ICC / Dual Inspection performed by:

Print: N/A

Sign: *J. Clarke*

SCA: AD02

Date: 25-Aug-17

Work Order closed by:

Print: J. Clarke

Form 2017/03

Rev. Original 23 Sep 2014

Approved Manufacturing Facility 73-04



Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bushing No. of pieces: 267

Manufacturer: Aero Design LTD

Part No.: 100224-01 Serial/Batch No.: N/A

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2017-123

Remaining Tasks to be Performed: inspection ✓ JC AD02

Signature: Kathy Seran

Date: 18 Aug 2017 Lic. No. / SCA AD-10

In Process



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AMF 73-04

In Process

Remarks

Green tag issued 25 Aug 2017 JK

BUSHING/TUBE/GUIDE/THREADED LUG

General

These general instructions apply to bushings, tubes and similar round components used for Aero Design cargo baskets, mounting beams, and other products. Refer to the drawing, at the current revision, for dimensions and details. Selected drawings with applicable parts, drawings not listed may also apply:

69830 – Bell 206L/407 Mounting Beam
76630 – Bell 206L/407 High Mounting Beam
78633 – Airbus AS350 Aft Beam
78634 – Airbus AS350 Forward Beam
49215 – Lid Prop Bushing
49216 – Lid Prop Bushing

76423 – Airbus AS350 Attachment Hoop
94023 – Airbus AS350 XL Attachment Hoop
82715 – Airbus AS350 Short Step Assembly
82733 – Airbus AS350 Short Step Bracket
36274 – Handle Lever Bushing
36275 – Handle Support and Bushing

Work Order: 2017-123

Batch Quantity: ~~528~~ 319

Complete

(initial or SCA #)

Date Open: JULY 24, 2017

Part Number: 78634-04

1. Cut stock material:

- Enter material PO:
- Cut stock to length, + 0.03-0.06".
- Tag in-progress parts and place on in-progress shelf in machine shop.

PO: 17050

2. Turn stock material:

CAUTION: Using a lathe requires training and is not to be undertaken without adequate instruction and knowledge of the processes and settings involved. Do not attempt to fabricate parts on the lathe if you are unsure of what is required to safely produce the part.

Note: Not all steps may apply to all parts. Strike out any step(s) that does not apply.

Note: Feeds and speeds are recommended starting point for aluminum, steel, and stainless steel up to 1" in diameter using the appropriate inserts. Adjust for optimal performance and finish.

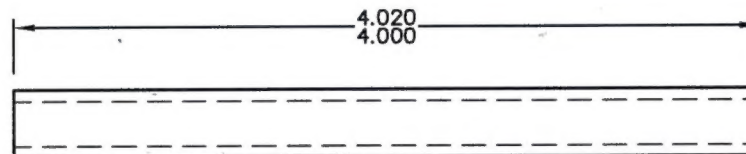
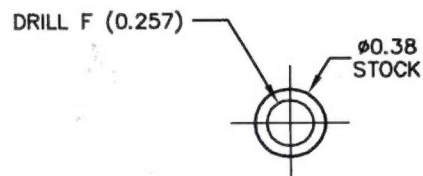
- Face one end flat @ 1000 RPM, cross feed @ 0.01"/rev roughing, 0.004"/rev finishing.
- Turn outside @ 1000 RPM, feed @ 0.01"/rev roughing, 0.004"/rev finishing.
- Centre drill and drill at 300 RPM (up to 5/16", reduce for larger sizes).
- Setup stop and face other end to length @ 1000 RPM.
- De-burr outside with a file and inside with a de-burring tool at 300 RPM.
- Tag complete parts.

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. 2017-0313
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3					5. Work Order/Contract/Invoice WO 2017-123
6. Item 1.	7. Description Bushing	8. Part Number 100224-01	9. Qty. 3	10. Serial/Batch No. N/A	11. Status/Work New
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  AD 73-04 02		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke - AD02		13e. Date (dd/mmm/yyyy) 12 Aug 2017		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	
<p align="center">Installer Responsibilities</p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

BLACKCOMB HELICOPTERS

THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING, OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREON.


REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



NOTES

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.

01 BUSHING

	100224-01	01	BUSHING	304 STAINLESS STEEL	ASTM A269	Ø0.375 X 0.065 TUBE
01	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
QTY	LIST OF MATERIALS					
	APPROVALS		DATE	 AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.483.2376 www.aerodesign.ca		
	DRAWN:	JEFF CLARKE	30 JUNE 2016			
	CHECKED:	JASON REKVE	30 JUNE 2016			
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1			AIRBUS HELICOPTERS AS350/AS355/EC130 BICYCLE RACK INSTALLATION BUSHING FABRICATION		
	SCALE 1 : 1		DWG. SIZE	DWG. NO.	REV.	
	SHEET 1 OF 1		A4	100224	0	

BUSHING/TUBE/GUIDE/THREADED LUG

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82733 – Airbus AS350 Short Step Bracket
36274 – Handle Lever Bushing
36275 – Handle Support and Bushing

Work Order: 2017-123

Batch Quantity: 46

Complete
(initial or SCA #)

Date Open: JULY 24, 2017

Part Number: 100224-01

1. Cut stock material:

- Enter material PO:
- Cut stock to length, + 0.03-0.06".
- Tag in-progress parts and place on in-progress shelf in machine shop.

JC. DP
PO: 15073

2. Turn stock material:

CAUTION: Using a lathe requires training and is not to be undertaken without adequate instruction and knowledge of the processes and settings involved. Do not attempt to fabricate parts on the lathe if you are unsure of what is required to safely produce the part.

Note: Not all steps may apply to all parts. Strike out any step(s) that does not apply.

Note: Feeds and speeds are recommended starting point for aluminum, steel, and stainless steel up to 1" in diameter using the appropriate inserts. Adjust for optimal performance and finish.

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- Tag complete parts.



Type: Bush ing

Work Order:

Work Order: 2017-123

[illegible]